

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007350**Date Inspected:** 18-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

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|------------------------------------|------------------------------|-----------|------------|----------------------------------|------------|---------------|
| CWI Name: | Zhu Zhong Hai and Li Yan Hua | | | CWI Present: | Yes | No |
| Inspected CWI report: | Yes | No | N/A | Rod Oven in Use: | Yes | No N/A |
| Electrode to specification: | Yes | No | N/A | Weld Procedures Followed: | Yes | No N/A |
| Qualified Welders: | Yes | No | N/A | Verified Joint Fit-up: | Yes | No N/A |
| Approved Drawings: | Yes | No | N/A | Approved WPS: | Yes | No N/A |
| | | | | Delayed / Cancelled: | Yes | No N/A |
| Bridge No: | 34-0006 | | | Component: | OBG | |

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA inspector performed MT of approximately 15% and VT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as 5BE Floor beam (Cross beam). The weld designations reviewed are as follows:

Bay 14

1. SSD27-PP332-037, 038, 115, 116, 140, 189, 190, 192, 193, 201, 202, 204, 205, 207, 210 and 213.

Bay 14

SAW welding of weld joint 006 on SEG059A*.

Welder is identified as Mrs. Xu Peipei (050323). ZPMC QC is identified as Mr. Shen Fu You.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

Bay 13

WELDING INSPECTION REPORT

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FCAW welding of weld joint 091 on SSD18-PP70.

Welder is identified as Mr. Cao Xiang Long (069683). ZPMC QC is identified as Mr. C.M. Chen.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint 130 on SSD9-PP61.

Welder is identified as Mr. Pan Meng (066673). ZPMC QC is identified as Mr. C.M. Chen.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2-F.

Bay 19

FCAW welding of weld joints 021, 022, 027 and 028 on SB012-052.

Welder is identified as Mr. Xie Biwu (062787). ZPMC QC is identified as Mr. Liu Fa Wen.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joints 045, 046, 051 and 052 on SB012-052.

Welder is identified as Mr. Zhang Shan hao (062763). ZPMC QC is identified as Mr. Liu Fa Wen.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

Out Side of Bay 14

SMAW welding of weld joint 007 on SEG042A.

Welder is identified as Mr. Xu Liguang (200114). ZPMC QC is identified as Mr. Zhu Zhong Hai.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114-B-U3b-FCM.

SMAW welding of weld joint 004 on SEG042A.

Welder is identified as Mr. Chen Hongjun (067609). ZPMC QC is identified as Mr. Zhu Zhong Hai.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114-B-U3b-FCM.

Bay 13

QA Inspector observed the removal of gusset plate (PCMK X96C) on Floor Beam FB014-029 (PP 62, Segment 8AE). Four X96C gusset plates were installed on this floor beam at the incorrect locations. QA Inspector issued an incident report on this date for the issue observed.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

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| Inspected By: | Alaniz,Joe | Quality Assurance Inspector |
| Reviewed By: | Carreon,Albert | QA Reviewer |
